

Work Order ID 60902

Monday, July 26, 2010 2:12:31 PM



Page 1

Item ID: K642-512

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-512

Start Date: 7/26/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 8/2/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: *H*Date: *10-7-24*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSI 9467

Rev A

IIN D206-642

Rev N

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Create White labels per PPP K642-512 CHG004

8/10/08/11/13

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/8/11 (12) 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____








NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			




NOTE: Date & initial all entries

Work Order ID 60902

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Item ID:	K642-512	Accept		Setup	Start	
Revision ID:						
Item Name:	saddle kit 642-512				Stop	
Start Date:	7/26/2010	Start Qty: 3.00		Cust Item ID:		
Required Date:	8/2/2010	Req'd Qty: 3.00		Customer:		
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop
						
						

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00		<i>Soloshic</i>		<i>(x3)</i>			
130  Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP K642-512	0.00 0.00		<i>RCUA</i>		<i>10/8/17</i>	<i>SP</i>	<i>(30)</i>	
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00		<i>PK</i>				<i>10/08/17</i>	<i>MF 10-8-17</i>

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Work Order ID: 60902

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010


Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00


Comments: IPP Rev:A 05.06.07 new issue EC
IPP Rev.B 05.02.08, Per ECN1080P

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C35A		Purchased	No			110	Each	80.0000	3	9		10/8/12	SP
													
S ₇₃ BOLT													


Location Loc Qty Loc Code

ST353	80	
111724	1	
112489	49	
114523	30	

AN3C36A		Purchased	No			110	Each	41.0000	9	27		10/8/12	SP
													
S ₇₃ BOLT													

Location Loc Qty Loc Code

ST353	41	
101261	4	
106541	6	
114653	31	

AN3C41A		Purchased	No			110	Each	117.0000	8	24		10/8/12	SP
													
S ₇₃ BOLT													

Location Loc Qty Loc Code

FG	4	
103324	4	
ST354	113	
108084	8	
112829	5	
114443	100	

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Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

AN4C6A

Purchased

No

110

Each

419.0000

12

36



Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

415

113121

215

115016

200

Location

Loc Qty

Loc Code

FG

4

104817

4

ST338

232

114443

62

114455

70

114523

100

AN5C11A

Purchased

No

110

Each

236.0000

8

24



Bolt

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

86

113121

86

AN5C12A

Purchased

No

110

Each

88.0000

4

12



Bolt

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

86

113121

86

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Work Order ID: 60902

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

AN5C13A

Purchased No

110

Each

106.0000

4

12



10/8/12 sl

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

104

107615

1

111648

3

113121

50

114615

50

12

AN5C15A

Purchased No

110

Each

93.0000

1

3



10/8/12 sl

Location

Loc Qty

Loc Code

ST339

93

111819

93

3

AN5C32A

Purchased No

110

Each

99.0000

2

6



10/8/12 sl 50

Location

Loc Qty

Loc Code

FG

4

18918

4

ST340

95

110155

4

111808

41

113164

50

6

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Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

AN5C34A

Purchased

No

110

Each

112.0000

2

6

10/8/12 sl



Location

Loc Qty

Loc Code

FG

2

18918

2

ST340

110

111648

50

112454

60

AN5C35A

Purchased

No

110

Each

97.0000

1

3

10/8/12 sl



Location

Loc Qty

Loc Code

ST340

97

107551

1

108084

50

108407

46

AN960C10L

NAS1149C0332

Purchased

No

110

Each

29.0000

24

72

M115000 10/8/12 sl (3x)



washer

Location

Loc Qty

Loc Code

ST245

29

107534

29

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 60902

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

AN960C416L

Purchased

No

110

Each

820.0000

24

72



WASHER

Location

Loc Qty

Loc Code

FG

44

104925

44

ST346

776

106785

38

107008

10

112794

287

112828

400

69220

41

72

AN960C516L

NAS1149C0532

Purchased

No

110

Each

6.0000

8

24



WASHER

Location

Loc Qty

Loc Code

ST347

6

111916

6

110

Each

1.0000

1

3

D206-648-013

Manufactured

No



GHW Modification

CHG7002

Location

Loc Qty

Loc Code

FG120

1

59234

1

61048

10/8/11 SP

B61238 2x

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 60902

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

D2652



Bushing

Manufactured No

110

Each

249.0000

16



48

10/8/10 SP
B6119 (11x)
10/8/10 SP

Location

Loc Qty

Loc Code

FG

44

31985

44

ST021

205

58176

42

59109

163

37

D2712



Set Screw

Manufactured No

110

Each

203.0000

10



30

10/8/10 SP

Location

Loc Qty

Loc Code

FG

50

29962

50

ST022

153

16400

20

34628

10

50415

123

30

D2932-2



Saddle RH Out, 206

Manufactured No

110

Each

13.0000

1



3

10/8/11 SP 30

Location

Loc Qty

Loc Code

ST421

3

53329

3

ST428

10

58266

4

60253

6

2

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Page 6

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Work Order ID: 60902

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

D2933-2

Manufactured No

110

Each

5.0000

1

3



Saddle RH In, 206



B60903 10/8/11 SP

Location

Loc Qty

Loc Code

ST428

5

52587

2

53330

3

D2934

Manufactured No

110

Each

70.0000

2

6



Saddle Spacer



10/8/11 SP

Location

Loc Qty

Loc Code

FG

6

31929

6

ST031

64

59641

64

D2935

Manufactured No

110

Each

56.0000

2

6



Saddle Spacer



10/8/11 SP

Location

Loc Qty

Loc Code

ST028

45

59642

45

ST031

11

50211

11

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 60902

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

D2938-2

Manufactured No

110

Each

8.0000

1

3



Saddle RH Out, 206



10/8/11 SF

Location

Loc Qty

Loc Code

ST421

3

53332

3

ST428A

5

58269

1

58533

4

Manufactured No

110

Each

7.0000

1

3

D2939-2



Saddle RH In, 206



60906 (2) 10/8/11 SF

Location

Loc Qty

Loc Code

ST428A

7

53334

3

58268

1

58535

3

Manufactured No

110

Each

43.0000

2

6

D3396-3



Spacer



10/8/11 SF (30)

Location

Loc Qty

Loc Code

FG

10

26772

10

ST055

33

36336

2

58680

31

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 60902

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

D3407-043

Manufactured No

110

Each

38.0000

1

3



Tow Ring



10/8/11 SP

Location

Loc Qty

Loc Code

ST464

38

50176

6

50387

20

53351

12

3

D3456-1

Manufactured No

110

Each

53.0000

1

3



Washer



10/8/11 SP

Location

Loc Qty

Loc Code

ST058

53

54692

53

3

D3457-1

Manufactured No

110

Each

63.0000

2

6



Washer



10/8/11 SP 3k

Location

Loc Qty

Loc Code

FG

10

32409

10

ST059

53

45913

2

52981

51

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 60902

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

D3672-1'



Phenolic Washer

Manufactured No

110 Each

1,015.000 24

72



10/8/11 SP

Location

Loc Qty

Loc Code

ST077

997

51674

5

52505

992

ST117

18

34470

18

34

18

D3672-3



Phenolic Washer

Manufactured No

110 Each

750.0000 24

72



10/8/11 SP

Location

Loc Qty

Loc Code

ST077

750

57704

750

Manufactured No

110 Each

676.0000 24

72



10/8/11 SP

Location

Loc Qty

Loc Code

ST077

676

53237

676

Purchased No

110 Each

2,985.000 20

72



10/8/11 SP (30)

D3672-7



Phenolic Washer

Manufactured No

110 Each

676.0000 24

72



10/8/11 SP

Location

Loc Qty

Loc Code

ST077

676

53237

676

Purchased No

110 Each

2,985.000 20

72



10/8/11 SP (30)

MS21043-3



Nut

Purchased No

110 Each

2,985.000 20

72



10/8/11 SP (30)

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2909

107280

4

112314

2905

60

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Parent Item Name: saddle kit 642-512

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 3.00

Required Qty: 3.00

MS21043-4

Purchased

No

110

Each

1,220.000

13

39



Nut



10/8/11 SP

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1180

112492

25

113069

8

114348

347

114523

500

114784

300

39

MS21043-5

Purchased

No

110

Each

612.0000

4

12



Nut



10/8/11 SP (30)

Location

Loc Qty

Loc Code

ST301

612

111819

112

112314

500

10

W/O:		WORK ORDER CHANGES					
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4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

Item	Qty -511	Qty -512	Qty -541	Qty -547	Qty -013	Part Number	Description
	X					D206-642-511	SKIDTUBE INSTALLATION, LH
		X				D206-642-512	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-541	SKIDTUBE
				X		D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D3274-041	SKIDTUBE ASSEMBLY
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			AN3C4A	* BOLT ⁽¹⁾
5A			2			AN960C10L	* WASHER ⁽¹⁾
5B			2			D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3C41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21043-3	NUT
12B	16	16				D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4				AN5C11A (or AN5C12A)	* BOLT ⁽²⁾
14	4	4				AN5C11A (or AN5C13A)	* BOLT ⁽²⁾
15A	8	8				AN960C516L	WASHER
15B	8	8				D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12				AN4C6A	BOLT
17A	24	24				D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24				AN960C416L	WASHER
18	12	12				MS21043-4	NUT
20A			9	9		D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A			1	1		D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A			1	1		D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B			1	1		D3536-15	* GASKET ⁽¹⁾
23A			1	1		D3535-23	* WEARSHOE ⁽¹⁾ (REPLACES D2656-23)
23B			1	1		D3536-23	* GASKET ⁽¹⁾
24A			1	1		D3535-39	* WEARSHOE ⁽¹⁾ (REPLACES D3287-1)
24B			1	1		D3536-39	* GASKET ⁽¹⁾
25A			1	1		D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B			1	1		D3536-35	* GASKET ⁽¹⁾
26A			78	78		AN3C4A	* BOLT ⁽¹⁾
26B			78	78		AN960C10L	* WASHER ⁽¹⁾
26C			78			ALS7-1032-130 (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)	* INSERT ⁽¹⁾
30	1	1				D3407-043	TOW RING
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34			1			AN4C5A	BOLT
35			1			AN960C416	WASHER
36			1			D3413-1	RING
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER

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ITEM	QTY -511	QTY -512	QTY -541	QTY -547	QTY -013	PART NUMBER	DESCRIPTION
40					2	D3414-041	LUG ASSEMBLY (GHW)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER
50	9	9				AN3C36A	BOLT
51	3	3				AN3C35A	BOLT
52	24	24				AN960C10L	WASHER
53	24	24				D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12				MS21043-3	NUT
55	2	2				D3396-3	SPACER
56A	1	1				AN5C35A	BOLT
56B	1	1				AN5C15A	BOLT
60	2	2				AN5C32A	BOLT
61	2	2				AN5C34A	BOLT
62	4	4				MS21043-5	NUT

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D3274-041 ASSEMBLY ABOVE
⁽²⁾ CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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